

Work Order ID 62587-2

Monday, October 04, 2010 3:45:47 PM

SPLIT



Page 1

Item ID: D2724-041

Accept



Setup Start



Revision ID:

Blue

Stop



Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

MF

Date: 10-10-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

10.10.07 4 0

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by
Jig
DT (One End Only)
A/R AL ROD Batch: M108436
Grind end cap welds flush M114877

10.10.20 4 0

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 - JE 10/10/21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 - 10/10/21

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 - 10/10/21

4 - 10/10/21

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Stop



Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10.10.21

4 0

Quality Control

160

Large Fab

0.00



Large Fab

Memo

0.00

Inspect for foreign object per QSI 024
Weld Remaining end cap as per Dwg D2724 using Jig DT8884 followed by Jig
DT
A/R AL ROD Batch: M108436
Grind per dwg D2724

10.10.22

4 0

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

4 0 BE10/10/25

Quality Control

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Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/10/10/25

Memo



190



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BR 10-10-25

Memo



205



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

0.00

Memo

PRIME B 115967
PAINT DELFLEET BLUE B 115509
CLEAR DELFLEET BLUE B 115949

ml 10 11 02 (2)

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Revision ID:

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Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Quality Control

Memo

0.00

10 11 03 2

220

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

2 BR 10-11-4

230

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

=> 10/11/04

2 0

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Setup Start



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Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

Handwritten: 62587

Handwritten: 10/11/09



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten: ch 10/11/09

Handwritten: MF 10-11-9

Picklist Print

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Page 1

Work Order ID: 62587



Parent Item: D2724-041



Parent Item Name: 206L Step Assembly

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C



Step Extrusion

Manufactured

No

100

Each

156.4200

1

4



10.10.07

Location

Loc Qty

Loc Code

WA

156.42

55214

3.42

58544

25

61208

128

110

Each

67.0000

1

4



10.10.19

D2734



Step End Plate

Manufactured

No

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

110

Each

25.0000

2

8



10.10.19

D3458-1



Step Mounting Plate

Manufactured

No

Location

Loc Qty

Loc Code

WA

25

51239

3

53408

22

110

Each

8.0000

2

8



10.10.19

D3458-3



Step Mounting Plate

Manufactured

No

Location

Loc Qty

Loc Code

WA

8

53409

8

6
2

Picklist Print

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Page 2

Work Order ID: 62587



Parent Item: D2724-041



Parent Item Name: 206L Step Assembly

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

D2734

Manufactured No

160

Each

67.0000

1

4



Step End Plate



10-10-22

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

4

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Shop Packet Print

Page 2

DART

RELEASED

05.11.14

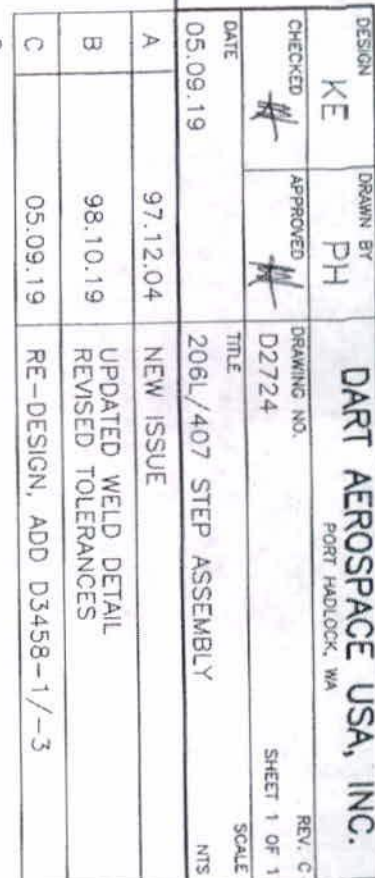


Diagram illustrating the geometry of the D2734 End Plate. The plate is shown attached to a cylindrical structure. Key dimensions and features include:

- Radius of End Plate: Indicated by a dimension line from the center of the cylinder to the outer edge of the plate.
- Thickness: Indicated by a dimension line showing the plate's thickness as 1.000.
- Angle: The angle between the plate's surface and the horizontal is 45.0°.
- Attachment: The plate is secured by a bolt and nut assembly.

TYPICAL STEP END DETAIL
NOT TO SCALE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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